

Work Order ID 113789

February-24-14 10:03:40 AM

113789

Page 1

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 2/24/14

Required Date: 2/24/14

Reference:

Start Qty: 20.00

Req'd Qty: 20.00

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: 14-02-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3537 Dwg Rev: ☒ Prog Rev: ☒ 2-
Deburr if necessary

0.00

0.00

21
24

EL 14-3-13

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

21
24

EL 14-3-13

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

21

14-03-14

DMS
9
9-89

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Work Order ID 113789

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Page 2

Item ID: D3537-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 2/24/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 2/24/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-------------------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Brake NC Brake NC | NC BRAKE Memo Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158 | 0.00 0.00 | | DAS 30 9-89 | | 21 | | | 14/03/14 |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D3429 | 0.00 0.00 | | | | | | | 14/03/14 |
| 150 *150* Large Fab Large Fab | Large Fab Memo Qty Description Batch A/R 2059B Hardcoat Weld Weld hardcoat as per Dwg D3437 M/27456 | 0.00 0.00 | | | | x6 | | | 14-03-17 MAL |



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Page 3

Item ID: D3537-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 2/24/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 2/24/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|-------------------|---------|--------------|---------------|---------------|------------------|-------------------|
| 160 *160* QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | DAS 24 2-89 | 14-3-17 | | 6* | | | |
| 170 *170* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | DAS 24 2-89 | 14-3-17 | | 6* | | | |
| 180 *180* Powdercoat Powder Coating | Grey Sandtex(Ref 4, 3, 5, 6) per QSI005 4.3 m 125008 Memo START TIME: 11:50 OVEN TEMPERATURE: 32° FINISH TIME: 11:20 | 0.00 0.00 | | | | 6 | 14-3-17 | | DAS 34 9-89 |

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Item ID: D3537-3 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Wearpad

Start Date: 2/24/14 Start Qty: 20.00 *20*

Required Date: 2/24/14 Req'd Qty: 20.00 *20*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|---------------------------|----------------|
| 190 *190* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 6 | 20 | 14/03/17 | |
| 200 *200* Packaging Packaging | Identify as per dwg & Stock Location: <u>FP001</u> Memo | 0.00 0.00 | | | | 6 | 20 | 14/03/17 | |
| 210 *210* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 14-03-18 MK 14-3-17 | |



Picklist Print

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Work Order ID: 113789

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Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 2/24/14

Required Date: 2/24/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

100

sf

217.1370

0.149

4

M304S16GA

**

02 / 4.3 / 13

304/316 Sheet 063

Location

MAT020

M126915

M127821

M128054

Loc Qty

217.137

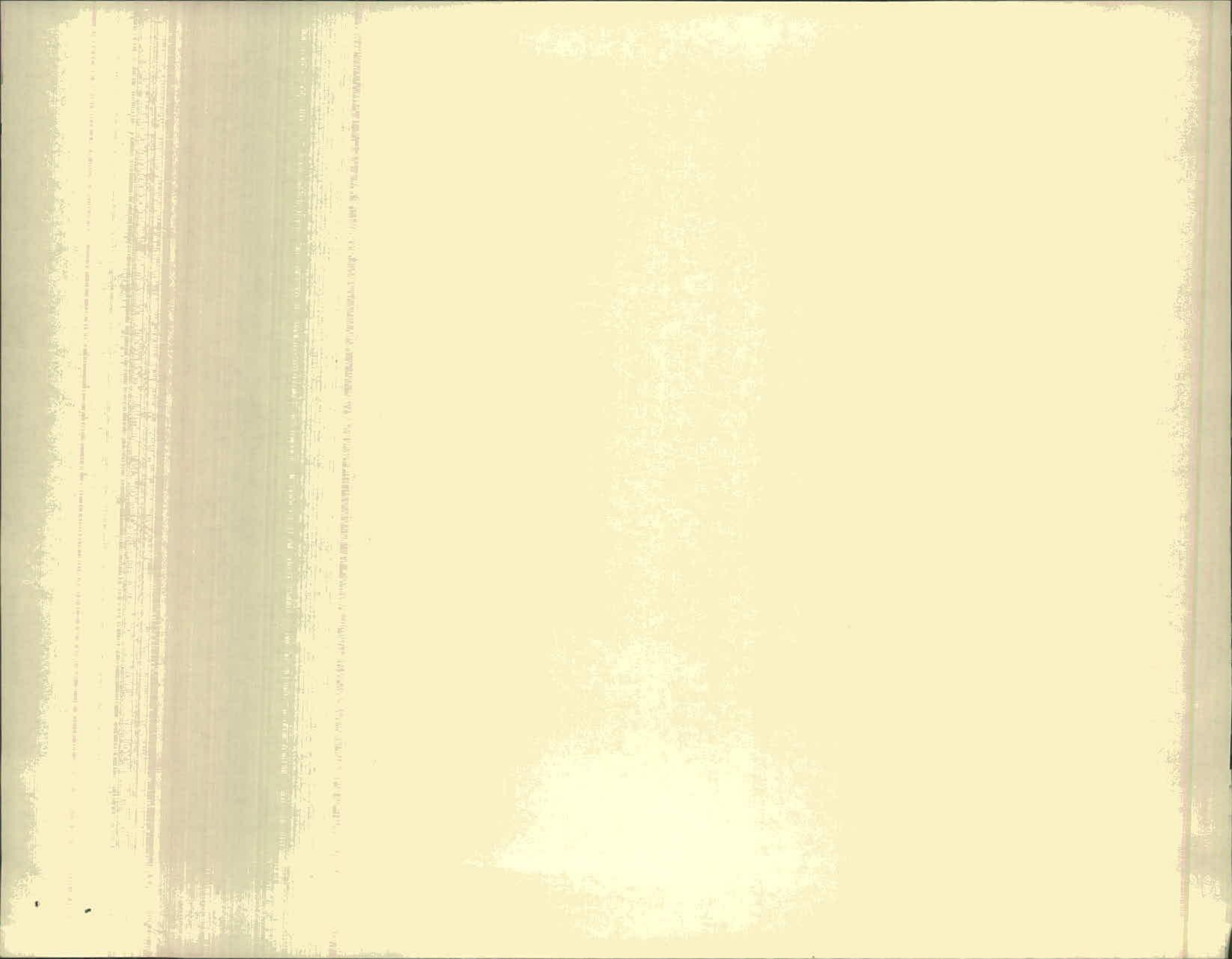
1.487

129.33

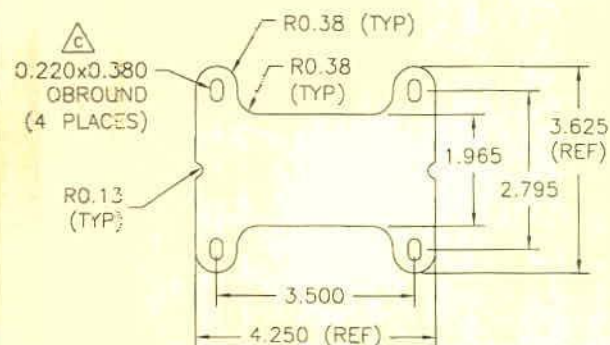
86.32

Loc Code

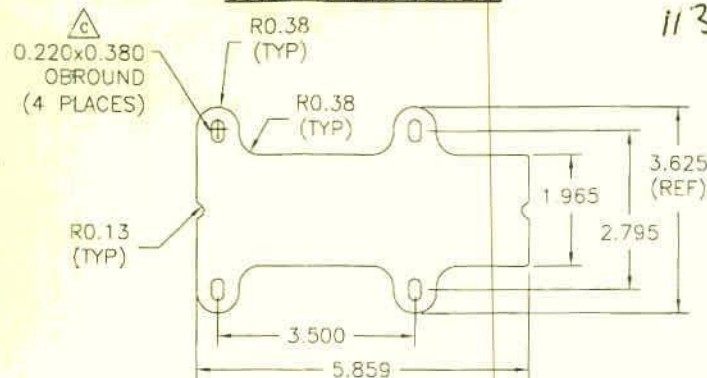
4.16



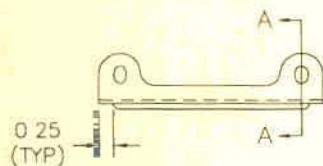
D3537-1F FLAT PATTERN



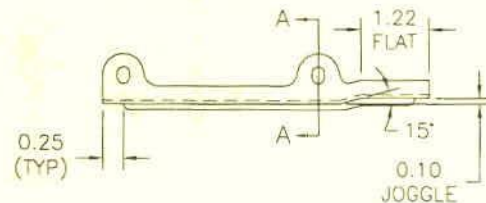
D3537-3F FLAT PATTERN



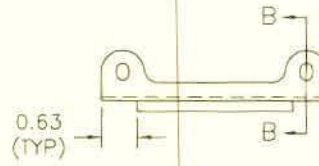
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



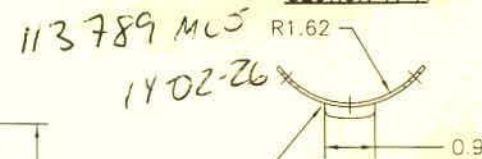
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

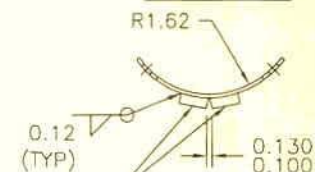
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

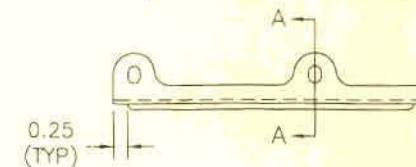
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
02-05-08 AH
PCR ECU
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



| | | |
|---------|----------|----------------------------------|
| C | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B | 07.03.20 | ADD AMS 5513 AND AMS 5524 |
| A | 06.11.06 | NEW ISSUE |
| DESIGN | C.B. | DRAWN BY |
| CHECKED | A | APPROVED |
| DATE | 07.04.13 | DRAWING NO. |
| | | D3537 |
| | | TITLE |
| | | WEARPAD |
| | | REV. C |
| | | SHEET 1 OF 1 |
| | | SCALE |
| | | 1:2 |

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